CLAIMS

1. A brazing process to join two metal parts (1, 3, 11), at least one of said parts (1) being tubular, the process comprising the steps of:

- positioning a brazing filler metal (5, 6, 18) on one of said metal parts;
- fixedly aligning the metal parts to be joined;
- heating said metal parts to a temperature at which the filler metal melts;

wherein, said filler metal is positioned proximate said tubular metal part prior to melting.

2. The process according to claim 1, wherein said heating step is carried out in a furnace.

3. The process according to claim 1, wherein said filler metal is in the form of a preformed metal object.

4. The process according to claim 3, wherein said preformed object is a folded metal wire.

5. The process according to claim 1 wherein the end (4) of a tube (3) is brazed into a hole provided in a lateral wall (2) of another tubular metal part (1).

6. The process according to claim 5, wherein a coating (5) of filler metal is applied or deposited around the end of said tube and the end of the tube is then inserted into said hole.

7. The process according to claim 5, wherein a preformed metal object is positioned around the end of said tube and the end of the tube is then inserted into said hole.

8. The process according to claim 7, wherein said preformed metal object is a ring (6) of metal wire.

9. The process according to claim 8 wherein said ring is positioned in a receiving groove (7) provided around the end of said tube.

10. The process according to claim 5, wherein the end of said tube is tapered.

11. The process according to claim 5 wherein the end of the tube is refashioned after it has been inserted into said hole.

12. The process according to claim 5, wherein the end of said tube is inserted into said hole so as to protrude into the inside of said tubular part a distance of from 1 to 3 mm.

13. The process according to claim 1, wherein a stopper (11) is brazed to form a closure in the end (12) of a tubular manifold (1).

14. The process according to claim 13, wherein said stopper has an internal face (15) provided with receiving means (19, 20) for holding a preformed filler metal (18) in proximity to the junction to be brazed.

15. The process according to claim 14, wherein the portion of the stopper inserted in said tubular manifold has a step (14), which forms the junction with the internal surface (17) of the manifold to be brazed.

16. The process according to claim 14, wherein said receiving means for holding the preformed filler metal (18) in proximity to the junction to be brazed includes a housing (19) formed along the external edge (13) of the stopper.

17. The process according to claim 16, wherein said receiving means for holding the preformed filler metal comprises a plurality of projections (20) provided on the internal face (15) of the stopper.

18. The process according to claim 5 wherein, the metal parts to be joined are parts of a towel-rack type radiator.

19. A stopper (11) for closing the end of a tubular manifold (1), having an internal face (15), provided with receiving means (19, 20) for holding a preformed filler metal in proximity to the surface of the manifold forming a junction to be brazed.